

Standards :

TS EN ISO 3581 - A	:	E 19 9 LR 32
EN ISO 3581 - A	:	E 19 9 LR 32
AWS A5.4	:	E 308 L - 16

**Chemical Composition of Weld Metal-
% (Typical) :**

C	Si	Mn	Ni	Cr
0.03	0.8	0.9	10.5	20.0

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20 °C)	Elongation (L ₀ =5d ₀)(%)
min. 355	520-660	min. 47 J	min. 35

Typical Base Material Grades :

* X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X2CrNiN 18 10, X10CrNiNb 18 10, X12CrNi 18 8, 304 L, 304, 304 LN, 321, 347, 302

Features and Applications :

* Rutile-coated low-carbon electrode for use in chemical, petrochemical and food industries where similar steel types, including higher carbon grades as well as ferritic 13% -Cr steels are welded. Resistant to corrosion and cracks. Working temperatures up to +350°C
Re-drying : 300-350 °C / min. 2 h

Welding Positions :



Current Type :

D.C.(+)
A.C.

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	50 - 90	1500
3.20 x 300	1/8 x 12"	80 - 120	2930
3.20 x 350	1/8 x 14"	80 - 120	3510
4.00 x 350	5/32 x 14"	110 - 160	4935

Approvals :

TSE, BV, CE, ABS, GOST-R, SEPRO, HAKC (3.20 mm), CWB